Work Order ID March-12-13 1:54:49			*984	120*						Page 1	
Item ID: D3202 Revision ID: Item Name: Cover	with,		Accept	*N900	040	100)*	Setup S	Start Stop	*N:	S1* S2*
Start Date: 3/11/1 Required Date: 3/29/1 Reference:	3 Start Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
	ess Plan: MCJ	_			ate:		I		Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		éject umber	Insp. Stamp
Draw Nbr	Revision Nbr										
D3202	Rev D										
100	FLOW WATER JET		0.00				Ŕ		<u>ح</u>		Im13-0
Waterjet FLOW CNC Waterjet	. Memo I-Cut as per Deburr if ne	Dwg D3202 Dwg Rev:_cessary	0.00 **Prog Rev:	<u>P</u> 2-							
*110 *110*	QC2- Inspect parts off m	achine FAI/FAIB	0.00				A	ح			Jn13-07
QC Quality Control	Memo		0.00				ب				<u> </u>

QC8- Inspect parts - second check

0.00

120

Quality Control

Memo

0.00 DAS B(N) B

NCR: Ye	s / No					WORK ORDER NON-C	O	IFORM	MANCE / UPE	DATE		•		,	\·
											• (QA Closed:	Da	te:	
Nork Order:	:					DISPOSITION				_	DEP	ARTMENT	,		,
Part No		····	.			Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.		Engineering Quality
NCR No	•	i-				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	_	Other
Root				Desc	rip	tion of work order update	П	nitial	Acti	ion		Sign &			
Cause	Date	Step	Qty		01	r Non-conformance	Ch	ief Eng	Descri	iption		Date	Verificatio	n	QC Inspector
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L	Centre No	ot Concer	ntric to C	o/s	╝	BOM/Route		Hardwa	re		'	Over/Under	tolerance		Temperature/Cure
	Cracks					Broken/Damaged		Inspect	on Incomplete			Part Incorred	ct	L	Weld
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	Cuffs			· [Contamination		Mainte	nance			Part Moved			
	Heat Trea	at		[Countersink		Mislabe	eled	[Positioned V	Vrong		_
	Inspectio	n Strip in	Tube	Ī		Cut Too Short		Misread	i	[Power Loss/:	Surge		Other
	Ripples in	n Bend		Ī		Drill Holes		Offset		_					
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Item ID: •Revision ID:	D3202-3		,	Accept	*N900	040°	100*	Setu	p Start Stop	14.	S1*	
Item Name:	Cover								Stop	*NS	52 *	
Start Date:	3/11/13	Start Qty: 6.00	*6*		Cust Item I	D:						
Required Date	e: 3/29/13	Req'd Qty: 6.00	*6*		Customer:							
Reference:				•								
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:		Run	Start	*NI	₹1 *	
i.	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*NI	R2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan A	-		Reject Number	Insp. Stamp	
130		Chemical Conversion C	oat per QSI005 4.1	0.00			_	~	a N	7 4	آسسے ا	
130 HandFinish		Memo		0.00				o	1067	13.7	<u>S</u>	
Hand Finishing												
140		Grey Sandtex(Ref:4.3.5	.6) per QSI005 4.3	0.00			12	/		1	1-1	
140 Powdercoat Powder Coating		Memo START TIN	4F. 11	40 0.00 OVEN TEMPERATURE			8_,	X \$ 1	MJ	13	107/0	6
N/2/12	19	3033	FINISH TIME:	12-10								
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Quanty Control											•	

										DQA:	Date	•
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Work Orde	j.				DISPOSITION			AGAINS	T DEF	PARTMENT	/PROCESS	
WORK OTUC					Rework	\Box		Skid-tube Crosstub	eП		Water Jet	Engineering
Part No	0.				Scrap			Machining Small Fa	-	Pro	d. Eng. Coor.	Quality
	***************************************				Use-as-is		Therm	noforming Finishin	g	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update			Large Fab Composit	e		Supplier	
		_ <u>_</u>	.,									
Root					ption of work order update		nitial	Action		Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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ŀ	Cracks			′ ⊢	Broken/Damaged			on Incomplete	Н	Part Incorre	i –	Weld
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Ì	Heat Tre	eat			Countersink		Mislabe	eled		Positioned V	Vrong	
	Inspecti	on Strip in	1 Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
[Ripples	in Bend			Drill Holes		Offset					
[Torque	Torque Waves in Extrusion Drawing					Out of Calibration					
	Turning	Sequence	?		Finish		Out of S	Sequence				
Ī	Wave/Twist in Tube Folio						Outside Dimensions					

Work Orde March-12-13 1:5		3420		*98420*									
Revision ID:	D3202-3 Cover			Accept	*N900040	100*	Setup Start Stop	*NS1* *NS2*					
	3/11/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:			14.17					
Approvals:	Process Pla	an:	Date:		Date:	-	Run Start Stop	"NRT"					
Sequence ID/ Work Center ID 160 *160* Packaging Packaging)	Operation Description Identify as per dwg & St	ock Location: 8724	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan According Code Qty	Reject Qty	Reject Insp. Number Stamp					
170 *170* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00			13/7	10 H					

W13-07-10

											DQA:	Date	::
NCR:	Yes	/ No	i i			WORK ORDER NON-C	01	NFORM	MANCE / UPDATE				
		 									QA Closed:	Date	2:
Work Orde	er.					DISPOSITION			AGA	INST DE	PARTMENT,	/PROCESS	
Part N	. No					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Cross Machining Small noforming Finis Large Fab Compo	l Fab hing	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						·							
						F/	AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped at		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4 `	on Incomplete ions Incomplete/Unclear nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Г	Ripples in				Drill Holes		Offset		<u> </u>	•	- L.	

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

March-12-13 1:54:49 PM

Work Order ID:

98420

Parent Item:

D3202-3

Parent Item Name:

Cover

Start Date: 3/11/13

Required Date: 3/29/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032 5052-H32 .032 Sheet		Purchased	No			100	sf	226.7000	1.551	2.7 9578 96	· · · · · · · · · · · · · · · · · · ·		Jm13-07-c
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		91							
				121	660	91							
				MAT022		135.7							
				112	2664	10.4							
				115	638	12							
				116	6657	9.5	,			 			
				117	7798	34.8				-			
				121	1030	46							
				12:	040	23							

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125552

NCR:	Yes	/	No	

		•						_		DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-	-COI	NFORI	MANCE / UPDATE		QA Closed:	Date	:
Mark Orda					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Orde Part N	o				Rework Scrap Use-as-is		1	Skid-tube Crosstube Machining Small Fal	b g	i	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o			·	Work Order Update	_]		Large Fab Composite	e		Supplier] [_]
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Cause	Date	Step	Qty		or Non-conformance	_ Ct	nief Eng	Description		Date	Verification	QC Inspector
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<u>.</u>	Bending			` _	Bend	\perp	Grain		_	Ovalized	<u>_</u>	Pressure/Forced
ļ	Centre N	ot Conce	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		_	Over/Under		Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	} -	Weld
ļ	Crushed/	Crimped			Burrs		- 4	tions Incomplete/Unclear	_	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	<u> </u>	Mainte	enance		Part Moved		
[Heat Trea			L	Countersink		Mislabe			Positioned V	· -	7
	Inspectio	n Strip in	Tube		Cut Too Short	<u> </u>	Misrea	d		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in I	Extrusio	n [Drawing		Out of	Calibration				
	Turning S	Sequence	2		Finish		Out of	Sequence				
	Wave/Tv	e/Twist in Tube Folio					Outside	e Dimensions			- "	

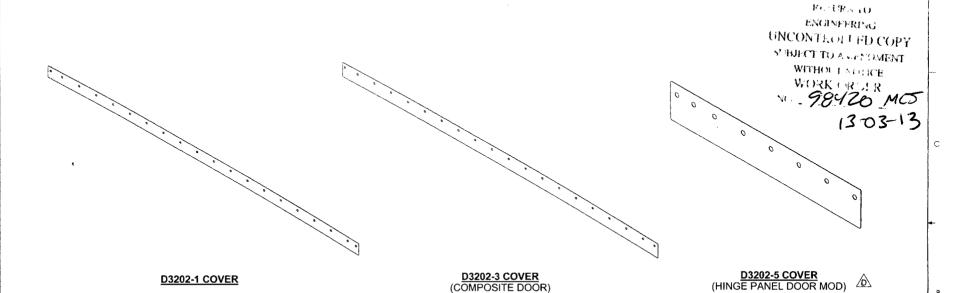
D3065-5DART AEROSPACE LTD	Work Order:	98420
Description: Cover	Part Number:	D3202-3
Inspection Dwg: D3202 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.38	+0.006/-0.001	0,382"			V	Jemus
0.56	+/-0.030	0.572"	-		ν	
3.59	+/-0.030	3.5%G'	-		V	·
2.95	+/-0.030	2.955"	_		V	
0.82	+/-0.030	0823"			ν	
74.85	+/-0.030	74.85"	_		Т	Jkm06
75.70	+/-0.030	75.70"			Т	
0.032	+/-0.010	0.030° 4.032°	-		ν	
4.03 Pitch	+/-0.030	4.032"	_		V	
		-				

Measured by: Jm	Audited by:	Preliminary Approval:
Date: 13-07-03	Date: Bloglog	Date:

	Rev	Date	Change	Revised by	y	Approved
	Α	08.07.23	New Issue	KJ/DD ₄△	انسا	
	В	12.09.26	Dwg Rev updated	KJ 😽	1 1	- hW/
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Str. LIST

ADD -3 FOR COMPOSITE DOOR, REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD, INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION) NOTES:
1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNILESS OTHERWISE NOTED RE-DESIGN PART NOW CURVED A NEW ISSUE DESCRIPTION REV. 1DS DESIGN DART AEROSPACE LTD AJS DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX CHECKED D3202 MFG. APPR. 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER TITLE APPROVED 7) WEIGHT: 0.56 lbs APPROX FOR -1

> DATE 08.11.03

COPYRIGHT © 2008 BY DART AEROSPACE LTD

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NOT THE USED FOR MAY PURPOSE OF COPPES OF COMMUNICATED TO MAY OTHER REPSON WITHOUT

3

DE APPR

COVER

: 0.61 lbs APPROX FOR -3

: 0.18 lbs APPROX FOR -5

ADD -5 FOR HINGE PANEL DOOR MOD.

AJS

AJS

CP

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BY

08.11.03

08.03.31

03.10.16

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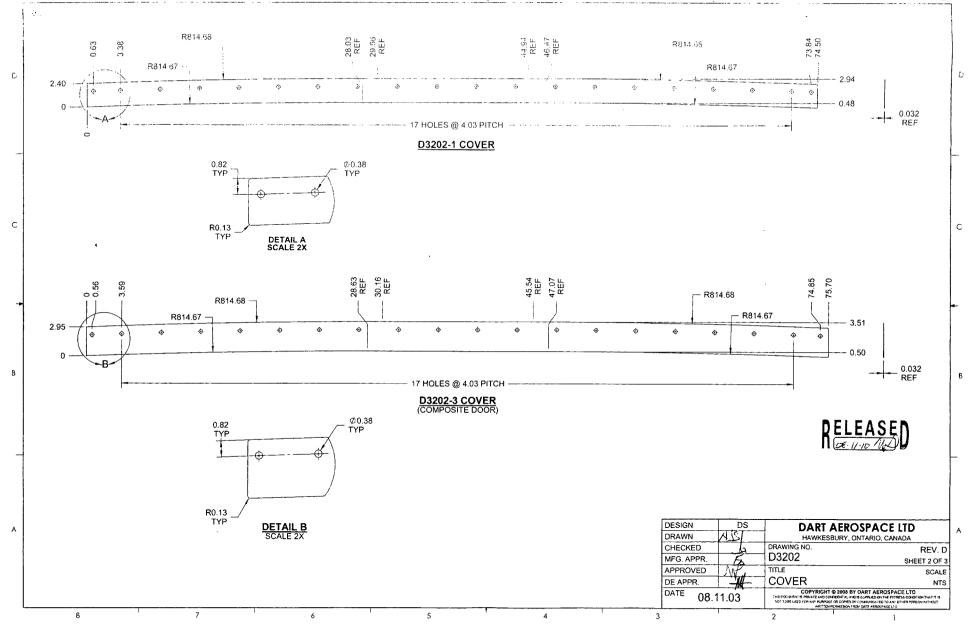
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SCALE

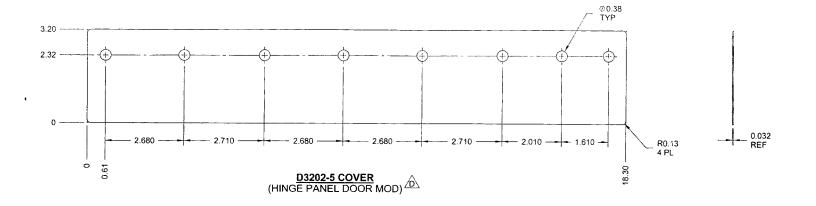
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SHEET 1 OF 3



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CHECKED	7	DRAWING NO.	REV. D	
MFG. APPR.	En	D3202	SHEET 3 OF 3	
APPROVED	MAL	TITLE	SCALE	
DE APPR.	-#	COVER	NTS	
DATE 08.	11.03	COPYRIGHT © 2008 BY DART AEROSPACE LYD HES DYCLMENT A REV. AT NO COPYRENT W. NOES SAPPING ON HIS EXPRESS CONTROL THAT IT IS NOT TO BE USED FOR ANY PLAPORT ON COPYRED ON COMMANDATION TO MY OTHER PERSON WITHOUT THE USED FOR ANY PLAPORT ON COPYRED ON COMMANDATION ON THE PERSON WITHOUT WHITH PERSON WE PROMISE AND ANY PLAPORT OF THE PERSON WITHOUT THE PERSON WE PROMISE AND ANY PLAPORT OF THE PERSON WITHOUT THE PERSON WE PROMISE AND ANY PLAPORT OF THE PERSON WITHOUT THE PERSON WE		

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